DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029820
Date Inspected: 17-Jul-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	William Sherwood and Fred Michel			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At bikepath panel point PP117 to PP121 south side, ABF personnel were noted tack welding 40 ½" long x 1 ¾" wide x 5/16" thick plate in between two handrail panels. According to ABF/QC William Sherwood, the plates are being welded to close the opening between the two handrails for safety purposes. ABF welder Rick Clayborn was observed perform the tack welding using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4r electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A.

During the shift while the welder was tack welding two different widths of plate closure to the handrail opening, Caltrans Engineer Sebastian saw it and questioned the installation of two different widths of plate. According to the Caltrans Engineer, the look of the two different widths of plate does not seem acceptable. Mr. Sebastian talked to ABF Superintendent Scott Smith about the issue and Mr. Smith stopped the welder from tack welding of the plates pending information from Caltrans.

FW Spencer:

At location Bikepath E panel point PP89 and OBG panel point PP126 Northeast, this QA randomly observed FW Spencer qualified welders Tim Esquivel, and welder Salvador Gomez continuing to perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on 2.5"

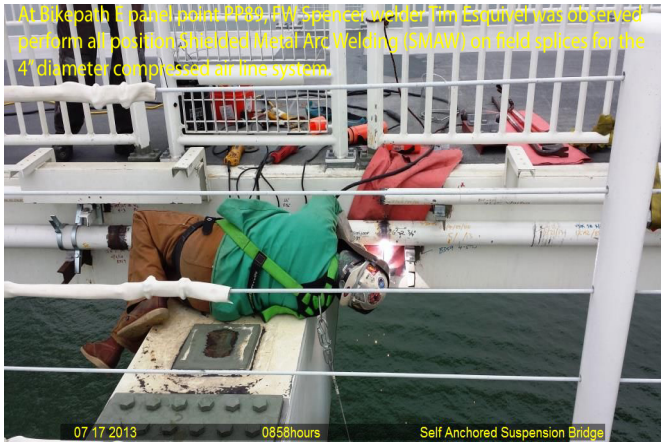
diameter domestic water line and 4” diameter compressed air field butt joints. The welders were noted welding the root pass with 3/32” diameter E6010 electrode and followed by fill pass to cover pass using 3/32” diameter E7018H4R electrode implementing Caltrans procedure FW Spencer WPS 1-12-1. The welders were noted preheating and removing the moisture of the joint using a portable propylene gas torch prior welding. During welding, ABF QC Fred Michels was noted monitoring the parameters of the welders. At the end of the FW Spencer shift, CJP welding on 2.5” and 4.0” diameter pipe joints at various locations were completed;

Tim Esquivel:

1. 62/4/89/BE Compressed Air service line
2. 67/2.5/89/BE Domestic water service line

Salvador Gomez:

3. 51/4/126/NE Compressed Air service line
4. 50/4/126/NE Compressed Air service line



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer